

Work Order ID 143869-2

March 24, 2016 11:48:20 AM

143869

Page 1

Item ID: D5061-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Fwd Wearplate

Stop *NS2*

Start Date: 3/31/2016 Start Qty: 10.00

10 8 SH
10 8

Cust Item ID:

Required Date: 4/8/2016 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: SH

Date: 20160324

Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5061	A								

110

110

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1- Cut as per Dwg
Dwg Rev: A
Prog Rev: F
2-Deburr if necessary

0.00

0.01

(8)

02/16/04/04

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

(8)

02/16/04/04

130

130

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

(8)

04/05/2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																									
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143869

Page 2

Item ID: D5061-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Wearplate
 Start Date: 3/31/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 4/8/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Form as per dwg NC BRAKE	0.01							APR 11 2016
140									
Brake NC	Memo	0.01			DAS 30 9-89	8			
Brake NC	Form joggle as per dwg.								
150	QC6- Inspect dimensions to drawing	0.00							DAS 38 9-89
150									APR 11 2016
QC	Memo	0.00				8			
Quality Control									
160		0.00							
160									
Large Fab	Memo	0.04							
Large Fab	Weld hard surface as per QSI 004 and Dwg D5061 2059 Hardcoat Rod <u>M130145</u>								

4 12/30/16 16-4-13

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
183		0.00							
183									
HandFinish	Memo	0.01							
Hand Finishing	APPLY ROCKGARD AS PER DWG								
	A/R ROCKGARD BATCH: <u>143278</u>								

48 16-04-13 41 9-89 16-4-13

DQA: _____ Date: _____



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
186 *186* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(4)			APR 14 2016
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-001</u> Packaging Memo	0.00 0.00							4 x of 2/16/14/14
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02							APR 14 2016 MLJ 2m 16/04/14 MLJ

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification
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Picklist Print

March 24, 2016 11:48:24 AM

Page 1

Work Order ID: 143869

143869

Parent Item: D5061-1

D5061-1

Parent Item Name: Fwd Wearplate

Start Date: 3/31/2016

Required Date: 4/8/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 14.02.13 NEW ISSUE DD VERF:JLM IPP
REV:B 14.03.12 rev.A10 DD VERF:JLM IPP REV:c
14.04.21 rev.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

sf

265.7960

37.68421

M304S18GA

304/316 .050 Sheet

03/16/16

Location

Loc Qty

Loc Code

MAT020

265.796

M133328

168.296

M133587

97.5

22.5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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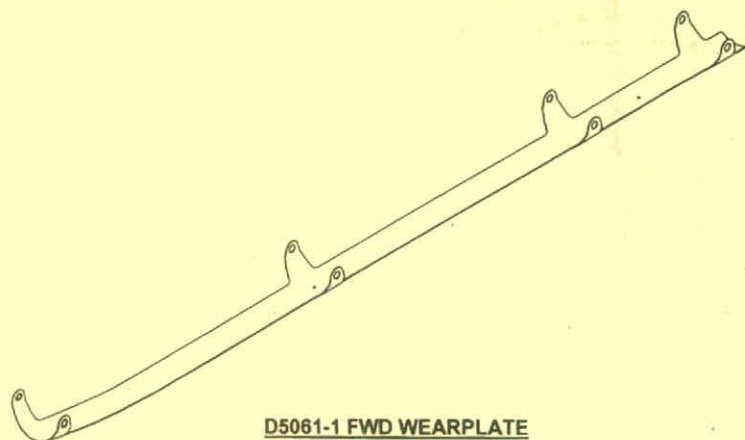
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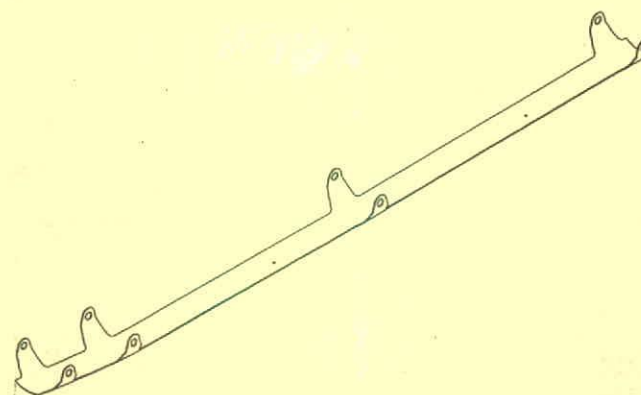
C

B

A



D5061-1 FWD WEARPLATE



D5061-3 AFT WEARPLATE

D

C

B

A

8 7 6 5 4 3 2 1

20160324

SH 143869

RELEASED
2014-04-15

APPROVED

REV. A	NEW ISSUE	AP	14.04.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5061	SHEET 1 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	14.04.08	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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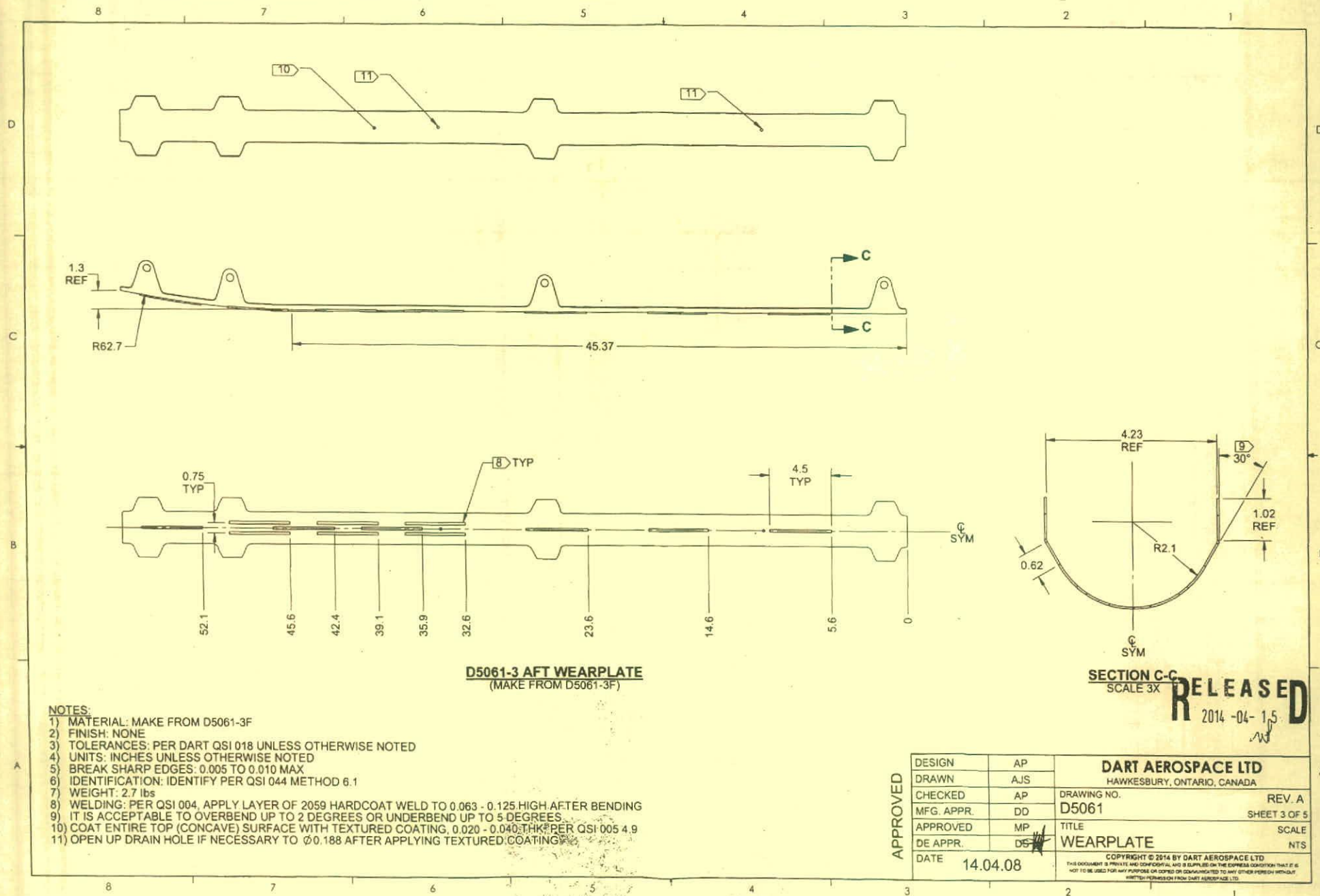


WORK ORDER NON-CONFORMANCE / UPDATE

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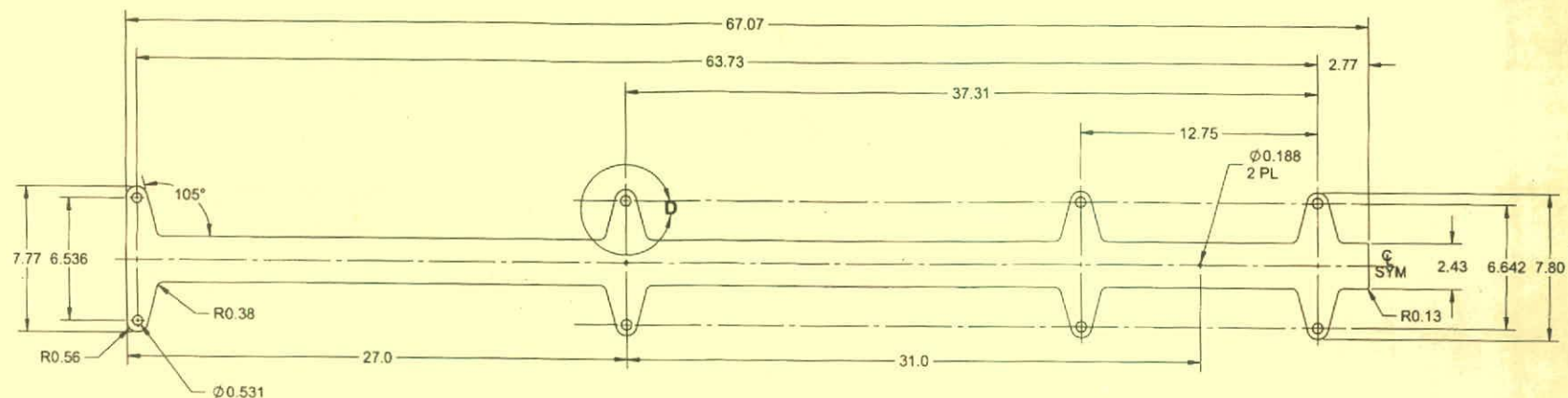


WORK ORDER NON-CONFORMANCE / UPDATE

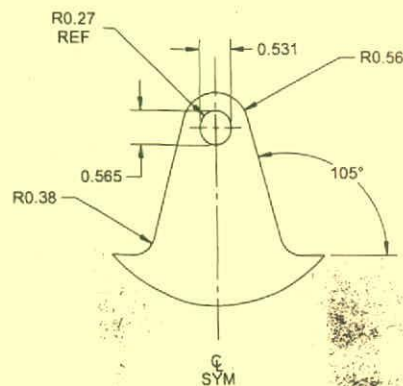
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Work Order update only ☐

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D5061-1F FWD WEARPLATE



DETAIL D
SCALE 3X
3 PL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
2014-04-15

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5061	SHEET 4 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	14.04.08	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DQA: _____ Date: _____

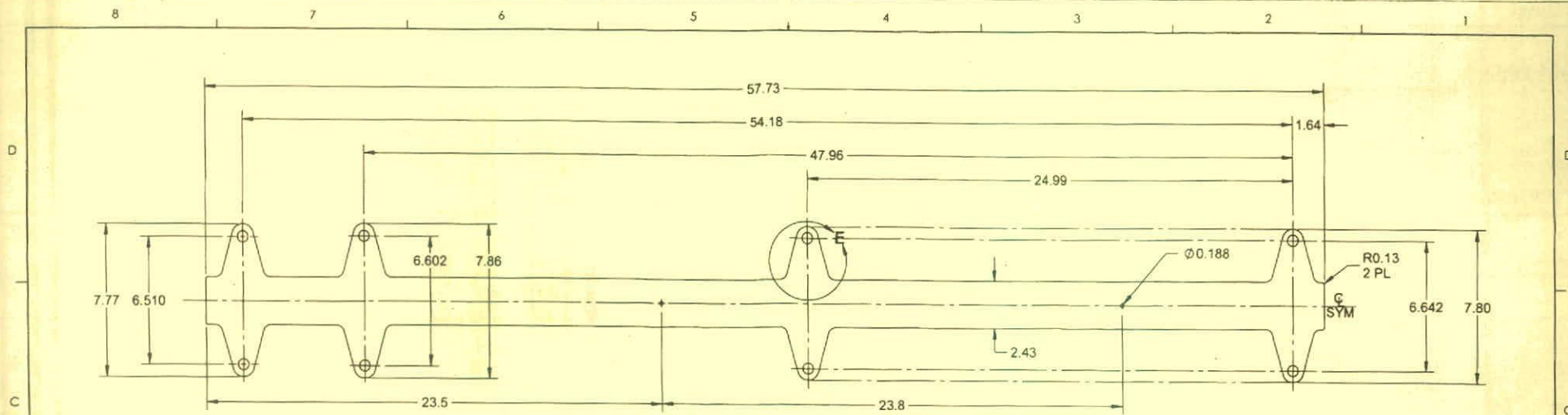


WORK ORDER NON-CONFORMANCE / UPDATE

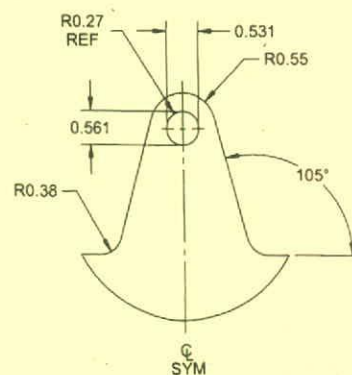
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Work Order update only ☐

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D5061-3F AFT WEARPLATE



DETAIL E
SCALE 3X
4 PL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
2014-04-15
AD

APPROVED

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5061	SHEET 5 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	14.04.08	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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